

Date: Tuesday, 14/04/2009 1:22:10 PM  
User: Chantal Lavoie

## Process Sheet

Split

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MIRROR ASSEMBLY 8"
Job Number	: 47152 -2	Part Number	: D3439101
Estimate Number	: 11291	Drawing Number	: D3439 REV A
P.O. Number	:	Project Number	: N/A
This Issue	: 14/04/2009 S.O. No. :	Drawing Revision	: A
Prsht Rev.	: NC	Material	:
First Issue	: / /	Due Date	: 21/04/2009
Previous Run	:	Qty:	2 Um: Each
Written By	:		
Checked & Approved By	: C209/04/14		
Comment	: Est. A05.07.20 New issue KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 8561

For Grote Mirror P/N: 12183

Possible Supplier: UAP/NAPA

Material release note is required

C209/04/14 (5)

2.0	12183	GROTE MIRROR
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Comment: Qty: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)  
MIRROR

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

C209/04/14 (2)

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Discard Hardware.

Fabricate stud as per Dwg D3439

Pick:

Qty Part Number Description Batch

1 5/16"-18UNCx1 1/4" Long Hex Bolt M111469

Drill and Tap mirror as per Dwg D3439, then install stud.

Coat threaded section of stud with LPS-3 before installing.




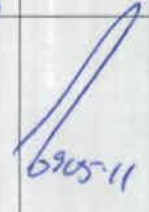
Pick:

Qty Part Number Description Batch

FF09-05-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3439-101 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 09/05/12  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>47152</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/05/07	4	Loosen backing screws to much, Backing plate came off. UNREPAIRABLE <u>Human ERROR</u> . This was done so we could drill & tap as per dwg.		DESTROY, NOT REPLACED	09/05/07 EB			

NOTE: Date & initial all entries



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Drawing Name: MIRROR ASSEMBLY 8"

Job Number: 47152

Part Number: D3439101

Job Number:



Seq. #:

Machine Or Operation:

Description:

A/RN/A

LPS-3

11094209

Crimp stud as per Dwg D3439

FF 09-05-07

(2)

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/05/11

(\*)

6.0

D30153

Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Lock Nut

Coat stud with LPS Procyon then install hardware loosely.

Pick:

Qty Part Number Description Batch

1 D3015-3 Lock nut

B45394

\* 1 5/16WC Washer

1110130

A/R N/ALPS Procyon

1104251

FF 09-05-07

(2)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Plug drain holes with Sikaflex.

Ensure that mirror adheres to housing.

Pick:

Qty Part Number Description Batch

A/RN/A Sikaflex-241/-291

0012195430/0269

Sikaflex expiry date 01/20/10

FF 09-05-07

(2)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/05/11

(2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57227

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## Process Sheet

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Drawing Name: MIRROR ASSEMBLY 8"

Job Number: 47152

Part Number: D3439101

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/11 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



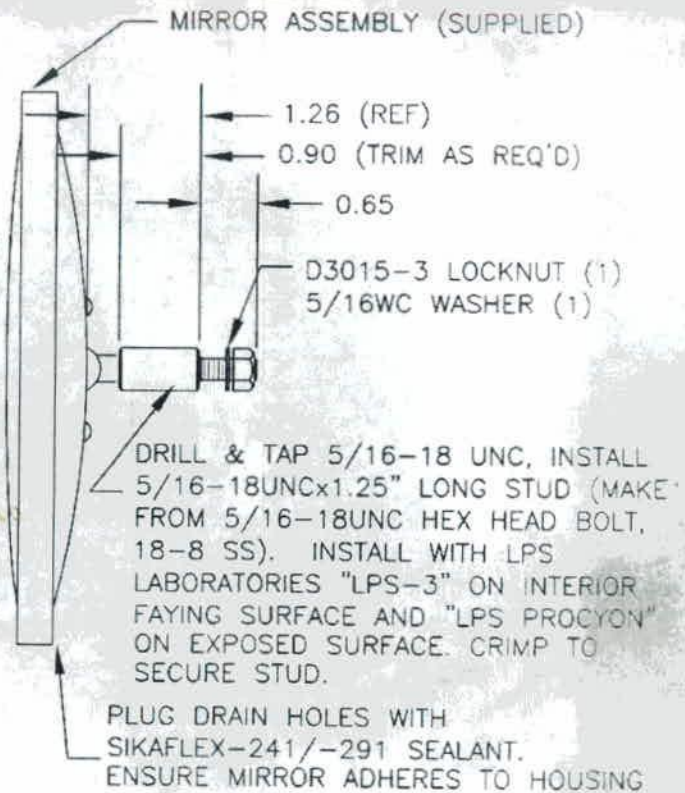
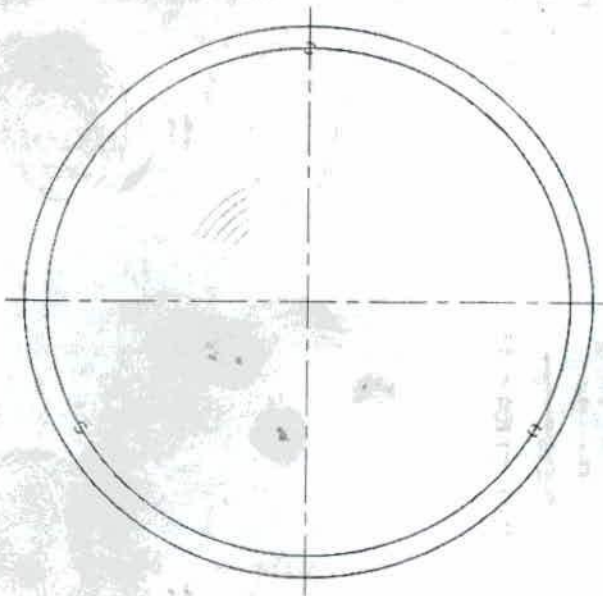
MF  
09-05-11





**DART**

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. A
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO.	SHEET 1 OF 1
				D3439	
DATE	05.05.27			TITLE	SCALE
				MIRROR ASSEMBLY	NTS
A	05.05.27			NEW ISSUE	

RELEASED  
# 05 05 27

QTY	Part Number	Description
-101		
X	D3439-101	MIRROR ASSEMBLY 8"
1	12183	MIRROR 8" (GROTE)
1	D3015-3	LOCKNUT
1	5/16WC	WASHER

**NOTES:**

1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

47152

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CUSTOMER COPY**



# DART

## Purchase Order

Date Apr 14, 2009	Page 1
Purchase Order Number PO00008555	

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7  
Phone: (613)632-9577  
Fax: (613)632-1053

**FXED**  
04/14/09

**Vendor Address:**

Aviall  
PO Box 9534  
Station A  
Toronto, ON M5W 2K3  
Phone (905) 676-1695  
Fax (905) 676-9046

**Ship To:**

Main Finished Goods Location  
Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-AVI001	Apr 14, 2009	N30	Fedex	Apr 17, 2009

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
200.0000 <i>New 100</i>	MS24694S98 <i>P 09/14/17</i>	Screw	17/04/2009	No	0.670000	Each	134.00
<div>CERTIFICATE OF CONFORMITY REQ'D UPON DELIVERY</div>							

**Comments:****Tax Summary:**

GST 6.70  
GSTME 0.00  
GSTND 0.00

Less:  
included tax

0.00

Subtotal

134.00

Total tax

6.70

Total purchase order in

CAD Dollars

140.70

Entered By: *CL* CLAVOIE

Approved By: *IN*